

Work Order ID 56277



Page 1

Wednesday, February 17, 2010 1:13:34 PM

Item ID: D350-636-014

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube RH

Start Date: 2/18/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 3/4/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: MF

Date: 10-2-17 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2750

Rev F

100

0.00



DOCUMENT CONTROL

DC

0.00

Memo

Document Control

Photocopy blue file and type labels per PPP D350-636-014 CHG 005

8/06/18

HJ for BG 10/03/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Date:

Stop

Sequence ID/
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DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

0.00

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 7 (D2750-4 details).Drill using drill Jig DT8150 & DT8864.

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8864 and cut as per dwg D2750.

4-Drill pilot holes for blade fitting bolt using DT8983. Open to 0.500".

5- locate DT8929 off of blade fitting holes and drill pilot holes for blade fitting.

6-Open up holes for section BE-BE to 0.375 (2 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open holes for ground handling and detail A-B to 0.500" (8 holes per side)

7-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 and open to 0.297"

8-Open up holes of Detail A-A to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004
A/R ☐ Aluminum Rod ☒ m113207 BE 12/10/10

10-Grind welds flush as per Dwg D2750

M10/2/22

M10/2/18

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Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

11- scribe batch #.

M 10/2/10

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

S 10/2/10

Memo

0.00

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S 10/2/10

Memo

0.00

40

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

M 10/2/10

W/O:		WORK ORDER CHANGES					
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Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

K/

BE 10/02/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Skidtubes

Skidtubes

Skidtubes

0.00

Memo

0.00

1-Open up holes section BE-BE 0.500" (4 per side) as per dwg D2750

2-Open holes section BC-BC 0.3125" (4 per side)

3-Open up holes of Detail AB and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

4-Chamfer holes of section BE-BE, BC-BC, AB and ground handling (welding instructions on sheet 11)

5-Deburr and blow out all chips from inside of tube. Prepare tube for welding, remove alodine as required.

6-Bond web D2739 in place as per QSI 015

A/R ☐ ☐ Sikaflex-291batch: 112429 ☐ ☐

exp. date: 12/25/09

7- Weld spacers D3490-1, D3490-5 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 11)

A/R ☐ ☐ Aluminum Rod

batch: M113207

BE 10/02/24

8-Grind welds flush as per Dwg D2750

9-Spot face ground handling holes (total of 4 places per side) as per dwg D2750

10-Deburr holes

M 10/2/23

DWM 10-2-25

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Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC10- Inspect visual per QSI004- ground welds

0.00

QC

Memo

0.00

Quality Control

8/10/26

180

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

8/10/26

190

Pressure Wash per QSI005 4.3

0.00

HandFinish

Memo

0.00

Hand Finishing

7/11 10/05/09

(X1) ✓

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M113170

BR 10/03/09

X1

Memo

0.00

START TIME: 1:45pm

OVEN TEMPERATURE: 320°F

FINISH TIME: 2:15pm

210



QC

Quality Control

QC3- Inspect Part Finish

0.00

BR 10-3-11

X1

Memo

0.00

Inspect for foreign object per QSI 024

220



HandFinish

Hand Finishing

HandFinishing

0.00

Memo

0.00

1-Install inserts as per dwg D2750

2-assemble o'ring as per dwg D3492 and apply o'ring lube
A/R 55-o'ring lube batch: M101223

BR 10-3-12

X1

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

230



HandFinish

HandFinishing

0.00

Hand Finishing

Memo

0.00

1-Assemble tube hardware as per dwg D2750

sikaflex batch

2-Inspect For Foreign Objects

3-Spray inside of tube with "LPS-3" batch:

4-Install blade fitting D3488-041, wearshoe

SIKA FLEX 241

BATCH:

EXP DATE:

5-assemble o-ring to plug as per dwg D3492 and apply o-ring lube

A/R 55-o-ring lube batch:

6-Coat all exposed fasteners with "LPS Procyon"

batch:

0.00

QC5- Inspect part completeness to step on W/O

0.00

Memo

240



QC

Quality Control

112345 10/108

10-3-15. ①

Scolaris

⑩

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID 56277

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Cust Item ID:

Required Date: 3/4/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00							
Quality Control									
270	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Package as per PPP D350-636-014								

New H

2/14/10 ①

②

2/16/10 ①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/24

MF

10-3-18

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

18

Work Order ID: 56277



Parent Item: D350-636-014



Parent Item Name: Skidtube RH

Start Date: 2/18/2010

Required Date: 3/4/2010

Comments: IPP Rev:H 02.09.25 Rearranged procedure steps KJ
 IPP Rev:I 05.12.08 Rearranged procedure steps EC
 IPP Rev:J 06.03.30 Per rev. D EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

Start Qty: 1.00

Required Qty: 1.00

D2600-3-BENT

Manufactured

No

110

Each

11.0000

1.0000



Extrusion Bent

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

9

50675

2

55462

7

Main Warehouse

ST

2

43495

1

47133

1

D2739

Manufactured

No

160

Each

6.0000

1.0000



350 I Beam

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

6

47124

1

55569

1

55986

4

1 11/2/13

1 11/2/23

W/O:		WORK ORDER CHANGES					
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 IPP Rev:J 06.03.30 Per rev. D EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

Start Qty: 1.00

Required Qty: 1.00

D2743



Crossbolt Spacer

Manufactured No 160 Each 179.0000 8.0000



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
LG	52	
50281	50	
51913	2	
Main Warehouse		
ST	127	
44891	2	
45555	17	
48275	1	
52310	107	

D2744



Cap

Manufactured No 160 Each 45.0000 1.0000



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	45	
44892	1	
47488	22	
51922	22	

8 BE 10/2/24

11 10/2/18

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Shop Packet Print

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 IPP Rev:J 06.03.30 Per rev. D EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

D3490-1 Manufactured No 160 Each 32.0000 4.0000



Cross Bolt Spacer

Warehouse Loc Qty Loc Code
Location

Main Warehouse
 ST 32
 48277 9
 51932 23

D3490-5 Manufactured No 160 Each 55.0000 4.0000



Cross Bolt Spacer

Warehouse Loc Qty Loc Code
Location

Main Warehouse
 ST 55
 43015 14
 46490 41

ALS4-1032-225 Purchased No 230 Each 6,296.000 38.0000



Insert

Warehouse Loc Qty Loc Code
Location

Main Warehouse
 ST 6296
 107441 16
 110768 6280

4 BE 10/02/24

4 BE 10/02/24

38 BE 10-3-15

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Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:H 02.09.25 ☐ Rearranged procedure steps ☐ KJ ☐

IPP Rev:I 05.12.08 ☐ Rearranged procedure steps ☐ EC ☐

IPP Rev:J 06.03.30 ☐ Per rev. D ☐ EC ☐

IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

AN3C5A

Purchased

No

230

Each

559.0000 34.0000



Bolt

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

114056

559

111424

8

111707

69

112314

1

113121

201

113149 ✓

274

113644

6

230

Each

766.0000 4.0000

AN3C6A

Purchased

No



BOLT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

111982 ✓

766

766

14. / 10-3-15.

20 / 10-3-15

4. / 10-3-15.

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Shop Packet Print

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 56277



Parent Item: D350-636-014



Parent Item Name: Skidtube RH

Start Date: 2/18/2010

Required Date: 3/4/2010

Comments: IPP Rev:H 02.09.25 Rearranged procedure steps KJ
 IPP Rev:I 05.12.08 Rearranged procedure steps EC
 IPP Rev:J 06.03.30 Per rev. D EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

Start Qty: 1.00

Required Qty: 1.00

AN6C44A Purchased No 230 Each 104.0000 4.0000



BOLT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	2	
103964	2	
Main Warehouse		
ST	102	
110105	4	
110155	14	
110665	1	
111605 ✓	32	
111649	50	
112720	1	

H. 10-3-15.

AN8C35A Purchased No 230 Each 128.0000 1.0000



BOLT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	128	
102180	1	
106896	1	
110105	48	
110847 ✓	78	

1 10-3-15.

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 56277



Parent Item: D350-636-014



Parent Item Name: Skidtube RH

Start Date: 2/18/2010

Required Date: 3/4/2010

Comments: IPP Rev:H 02.09.25 Rearranged procedure steps KJ

Start Qty: 1.00

Required Qty: 1.00

IPP Rev:I 05.12.08 Rearranged procedure steps EC

IPP Rev:J 06.03.30 Per rev. D EC

IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

AN960C10L

Purchased

No

230

Each

388.0000 38.0000



washer

WAS1149C0332R

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

103585

100

100

Main Warehouse

ST

112116

288

128

112612

160

38. bl 10-3-15.

AN960C816L

Purchased

No

230

Each

209.0000 1.0000



WASHER

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

104093

209

2

107520

4

110139

29

110584

100

111424

74

1 bl 10-3-15.

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 56277



Parent Item: D350-636-014



Parent Item Name: Skidtube RH

Start Date: 2/18/2010

Required Date: 3/4/2010

Comments:

IPP Rev:H 02.09.25 Rearranged procedure steps KJ

Start Qty: 1.00

Required Qty: 1.00

IPP Rev:I 05.12.08 Rearranged procedure steps EC

IPP Rev:J 06.03.30 Per rev. D EC

IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

D2745

Manufactured No

230

Each

274.0000 8.0000



Bushing



Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	36	
43754	2	
44893	33	
45556	1	
Main Warehouse		
ST023	23	
34817	2	
36230	8	
37303	1	
39587	2	
40726	2	
41114	2	
42778	6	
Main Warehouse		
ST46	215	
51537	34	
52311	181	

8.1K103-15.

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 56277

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

Comments: IPP Rev:H 02.09.25 Rearranged procedure steps KJ
 IPP Rev:I 05.12.08 Rearranged procedure steps EC
 IPP Rev:J 06.03.30 Per rev. D EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

Start Date: 2/18/2010

Required Date: 3/4/2010

Start Qty: 1.00

Required Qty: 1.00

D3488-042



Manufactured No 230 Each 12.0000 1.0000

Blade Fitting Assembly, RH

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 12

29043 1

52666 11

Manufactured No 230 Each 70.0000 8.0000

D3492-1



Plug

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 70

46101 1

46692 1

47472 1

47658 31

48274 36

replaces D3492-041

1/10-3-15

8/10-3-15

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 56277



Parent Item: D350-636-014



Parent Item Name: Skidtube RH

Start Date: 2/18/2010

Required Date: 3/4/2010

Comments: IPP Rev:H 02.09.25 Rearranged procedure steps KJ
 IPP Rev:I 05.12.08 Rearranged procedure steps EC
 IPP Rev:J 06.03.30 Per rev. D EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

Start Qty: 1.00

Required Qty: 1.00

D3492-5



Manufactured No 230 Each 47.0000 8.0000



Plug

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	47	
46993	1	
47659	46	

replaces D3492-045

D3535-25



Manufactured No 230 Each 5.0000 1.0000



Wearshoe

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	5	
52589	5	
56065		

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8 PR 10-3-15.

1 PR 10-3-15.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 56277

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

Comments:

IPP Rev:H 02.09.25 Rearranged procedure steps KJ

IPP Rev:I 05.12.08 Rearranged procedure steps EC

IPP Rev:J 06.03.30 Per rev. D EC

IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

Start Date: 2/18/2010

Required Date: 3/4/2010

Start Qty: 1.00

Required Qty: 1.00

D3536-25



Manufactured No

230

Each

30.0000

1.0000

Gasket



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP10

25

54479 ✓

25

Main Warehouse

ST

5

45569

1

47011

2

47526

2

Manufactured

No

230

Each

153.0000

3.0000

D3537-1



Wearpad



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

74

48288

2

55465 ✓

72

Main Warehouse

FP17

79

51678

1

51679

78

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 56277

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

Comments: IPP Rev:H 02.09.25 Rearranged procedure steps KJ
 IPP Rev:I 05.12.08 Rearranged procedure steps EC
 IPP Rev:J 06.03.30 Per rev. D EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

Start Date: 2/18/2010

Required Date: 3/4/2010

Start Qty: 1.00

Required Qty: 1.00

D3631-1



Washer

Manufactured No 230 Each 370.0000 8.0000



Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	370	
	52693 ✓	70	
	54388	300	

D3672-1



Phenolic Washer

Manufactured No 230 Each 1,700.000 4.0000



Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	1200	
	39275	19	
	42329 ✓	5	
	47628 ✓	176	
	52505	1000	
Main Warehouse	ST117	500	
	51674	500	

8. BR 10-3-15.

4. BR 10-3-15.

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 56277

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

Comments: IPP Rev:H 02.09.25 Rearranged procedure steps KJ
 IPP Rev:I 05.12.08 Rearranged procedure steps EC
 IPP Rev:J 06.03.30 Per rev. D EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

Start Date: 2/18/2010

Required Date: 3/4/2010

Start Qty: 1.00

Required Qty: 1.00

D3791-1



Wearplate

Manufactured No 230 Each 14.0000 1.0000



Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

12

55457

12

Main Warehouse

ST

2

51909

2

D3793-1



Wearshoe

Manufactured No 230 Each 11.0000 1.0000



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

11

40551

1

51597

10

1 Br 10-3-15

1 Br 10-3-15

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 56277

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

Comments:

IPP Rev:H 02.09.25 Rearranged procedure steps KJ
 IPP Rev:I 05.12.08 Rearranged procedure steps EC
 IPP Rev:J 06.03.30 Per rev. D EC
 IPP Rev:L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By:EC

Start Date: 2/18/2010

Required Date: 3/4/2010

Start Qty: 1.00

Required Qty: 1.00

D3793-3



Wearshoe

Manufactured No 230 Each 18.0000 1.0000



Warehouse
Location
Loc Qty
Loc Code

Main Warehouse
 FP19 11
 55458 ✓ 11
 Main Warehouse
 ST 7
 51592 7

1 B-10-3-15

D3794-1



Gasket

Manufactured No 230 Each 18.0000 1.0000



Warehouse
Location
Loc Qty
Loc Code

Main Warehouse
 FP 15
 51928 3
 55459 ✓ 12
 Main Warehouse
 ST 3
 46530 1
 47212 2

1 B-10-3-15

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 56277

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

Comments: IPP Rev:H 02.09.25 Rearranged procedure steps KJ
 IPP Rev:I 05.12.08 Rearranged procedure steps EC
 IPP Rev:J 06.03.30 Per rev. D EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

Start Date: 2/18/2010

Required Date: 3/4/2010

Start Qty: 1.00

Required Qty: 1.00

D3794-3 Manufactured No 230 Each 32.0000 1.0000
 Gasket

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
FP	9	
51907 ✓	9	
Main Warehouse		
ST	23	
46531	2	
47440	1	
56066	20	

MS21043-6 Purchased No 230 Each 964.0000 4.0000
 NUT

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	964	
112314 ✓	964	

1/2/10-3-15

4.1/10-3-15

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 56277

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

Comments: IPP Rev:H 02.09.25 Rearranged procedure steps KJ
 IPP Rev:I 05.12.08 Rearranged procedure steps EC
 IPP Rev:J 06.03.30 Per rev, D EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

Start Date: 2/18/2010

Required Date: 3/4/2010

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased No 230 Each 72.0000 1.0000



NUT

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	72	
110584	5	
111424	2	
113149 ✓	15	
113845	50	

NAS1611-005

Purchased No 230 Each 262.0000 1.0000



O-RING

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	262	
102022	8	
102093	1	
105939	1	
106099 ✓	252	

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 56277

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

Comments:

IPP Rev:H 02.09.25 Rearranged procedure steps KJ

IPP Rev:I 05.12.08 Rearranged procedure steps EC

IPP Rev:J 06.03.30 Per rev. D EC

IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

Start Date: 2/18/2010

Required Date: 3/4/2010

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010



O-RING

Purchased No 230 Each 322.0000 1.0000



Warehouse
Location
Loc Qty
Loc Code

Main Warehouse

ST 322

110715 44

110915 278

Purchased No 250 Each 126.0000 2.0000



AN8C21A



BOLT

Warehouse
Location
Loc Qty
Loc Code

Main Warehouse

ST 126

105160 1

107596 1

107924 2

109092 2

110341 2

110342 2

111605 50

112720 16

113558 50

PTO
Rup/170

m/12720

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10-3-11	230	DIAS/61-010 CHANGE FOR 2594-5 (B55546)	B	10-3-11	8.		S 10/3/11

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 56277

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

Comments: IPP Rev:H 02.09.25 Rearranged procedure steps KJ
 IPP Rev:I 05.12.08 Rearranged procedure steps EC
 IPP Rev:J 06.03.30 Per rev. D EC
 IPP Rev:L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By:EC

Start Date: 2/18/2010

Required Date: 3/4/2010

Start Qty: 1.00

Required Qty: 1.00

AN960C816L



WASHER

Purchased No 250 Each 209.0000 2.0000



Handwritten signature

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	209
104093	2
107520	4
110139	29
110584	100
111424	74

D2741



Blade, 350 Skidtube

Manufactured No 250 Each 22.0000 1.0000



Handwritten: M74 111424

Handwritten: 2/13/17 ①

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	22
51931	22

Handwritten: 51931

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

* NOTE: Date & initial all entries

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Work Order ID: 56277

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

Comments:

IPP Rev:H 02.09.25 Rearranged procedure steps KJ
 IPP Rev:I 05.12.08 Rearranged procedure steps EC
 IPP Rev:J 06.03.30 Per rev. D EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

Start Date: 2/18/2010

Required Date: 3/4/2010

Start Qty: 1.00

Required Qty: 1.00

D3493-1



Washer

Manufactured No 250 Each 37.0000 2.0000



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 37

44902 2

47710 35

Purchased No 250 Each

930.0000 2.0000



47710

D3672-13



Phenolic Washer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 930

54363 930

Purchased No 250 Each

72.0000 2.0000



54363

MS21083C8



NUT

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 72

110584 5

111424 2

113149 15

113845 50

1113845

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

* NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
1			1	D2750-4	SKIDTUBE WELDMENT, RH
	1			D3488-041	BLADE FITTING, LH
4	4	4	4	D3488-042	BLADE FITTING, RH
4	4			D3490-1	SPACER
		4	4	D3490-3	SPACER
			4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

56277

RELEASED

INCORPORATE DSI 9413. QTY (5) D3537-1 WAS QTY (5) (ZN C8-1). D3791-1/3 REPLACES D3535-13/35 (ZN C8-1). D3794-1/3 REPLACES D3536-13/35 (ZN B8-1). ADD D3781-1 (ZN C8-1). WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1). D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11). ADD NOTE 12 AND 13 (ZN A6-1). REASON: REF. NCR 08-043		PH	08.07.16
CHANGE TO STAINLESS STEEL WEARPLATES. ADD RUBBER GASKETS, CHANGE INSERTS, ADD D3631-1. REMOVE QTY (38) NAS1515H3L, REMOVE QTY (10) NAS1515H8L, REMOVE D2741, QTY (2) AN960C816, REMOVE QTY (2) MS21083C8		CB	07.05.17
ADD HOLES AND SPACERS FOR APICAL FLOATS. INCORPORATE DEO 9133/9157		PH	06.01.05
ADD D2750-3/D2750-4, INCORPORATE D2738 AND D2740		CP	98.11.18
CHANGE MS24694-S293 TO AN8-16A		CP	98.09.01
NEW ISSUE		DS	98.04.16
REV	DESCRIPTION	BY	DATE
DESIGN	PA	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	REH		
CHECKED	AL	DRAWING NO.	REV. F
MFG. APPR.	AL	D2750	SHEET 1 OF 11
APPROVED	AL	TITLE	SCALE
DE APPR.	AL	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED TO THE EXTENT PERMITTED BY THE EXPORT ADMINISTRATION THAT IT BE NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

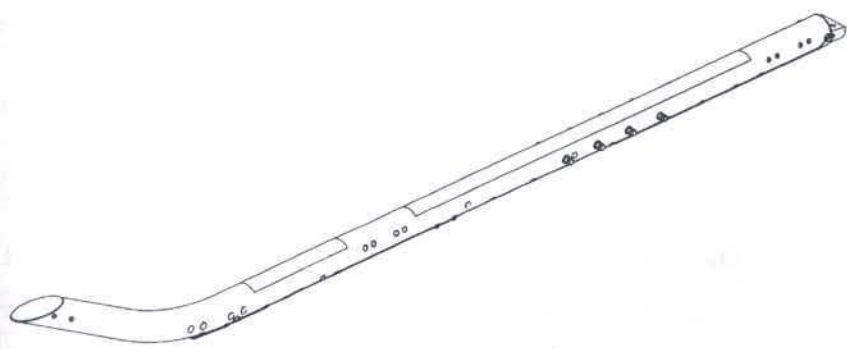
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

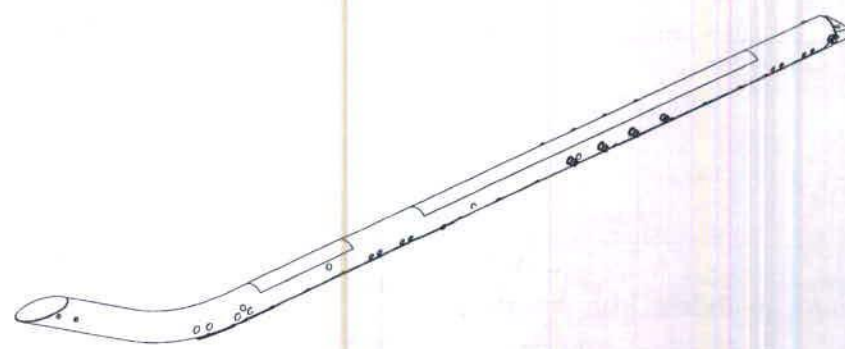
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

#56277



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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08.22.16

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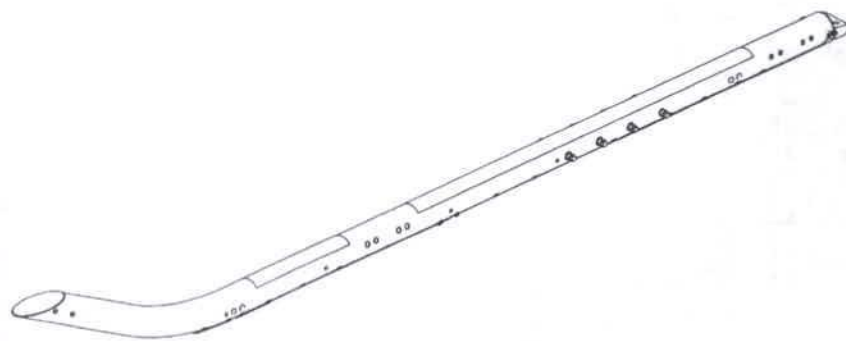
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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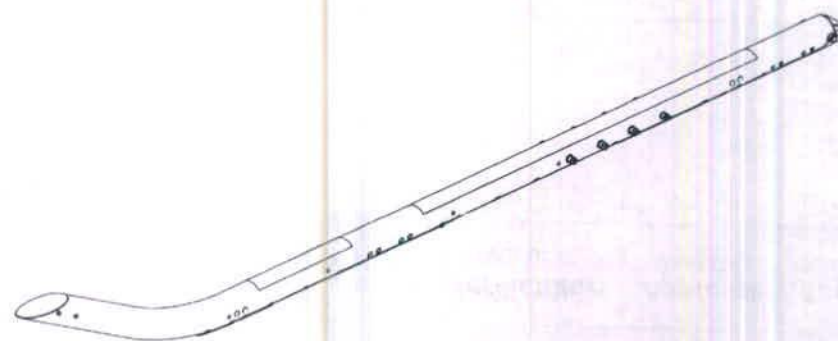
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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#56277



D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

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68-9-22-1-11

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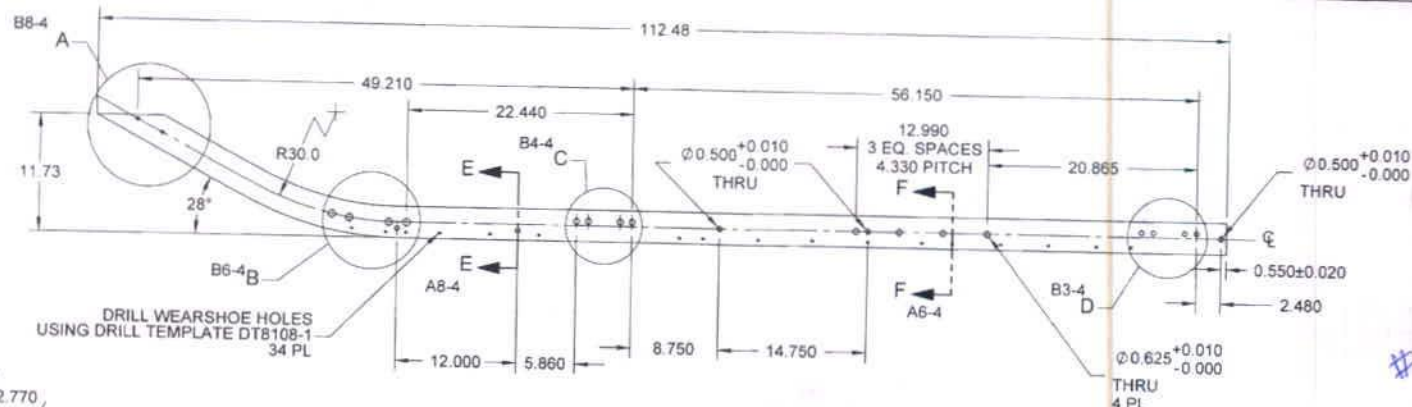
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

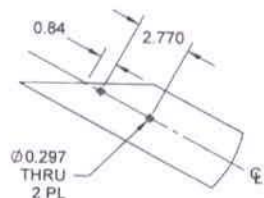
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

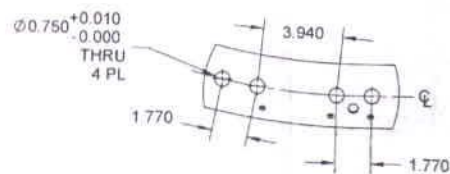
NOTE: Date & initial all entries



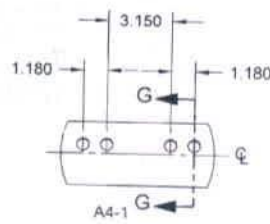
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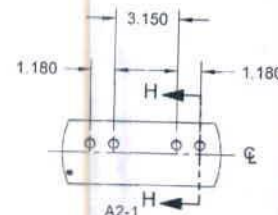
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SCALE 2X



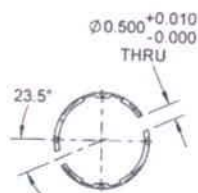
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SCALE 2X



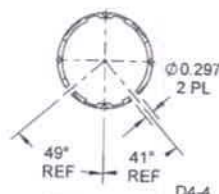
DETAIL C
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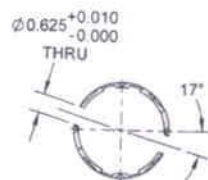
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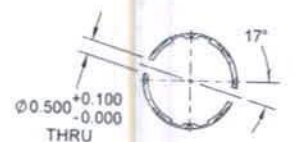
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

DESIGN	PA
DRAWN	PA
CHECKED	PA
MFG APPR	PA
APPROVED	PA
DE APPR	PA
DATE	08.07.16

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO. **D2750** REV. F
TITLE **350 SKIDTUBE ASSEMBLY** SCALE NTS
SHEET 4 OF 11

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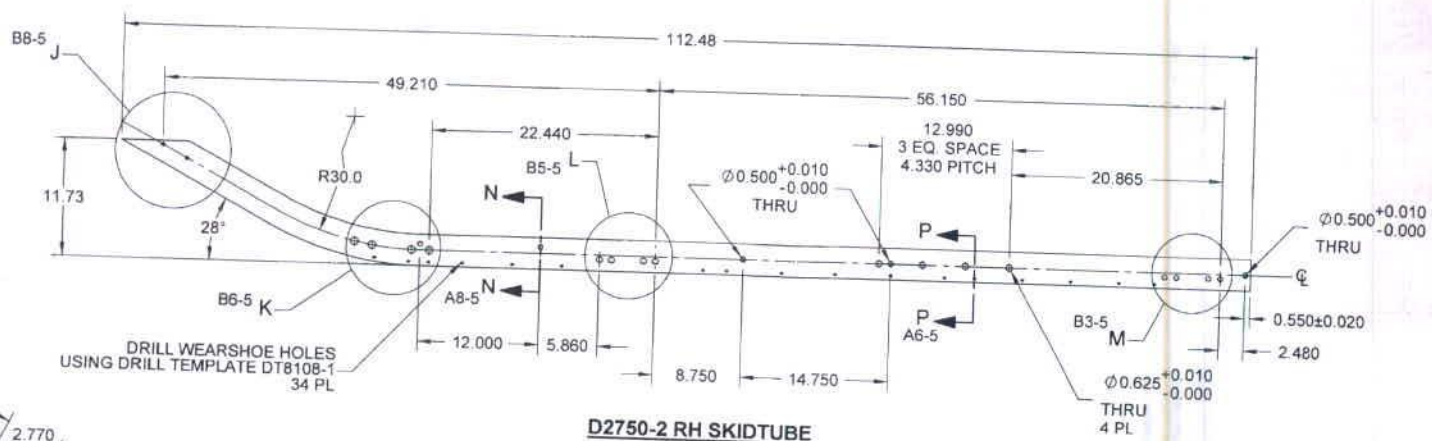
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

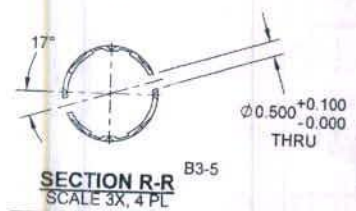
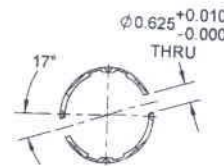
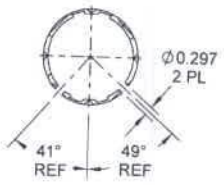
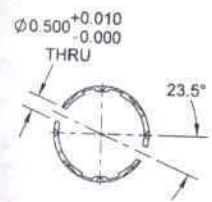
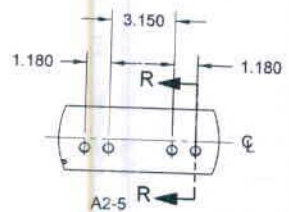
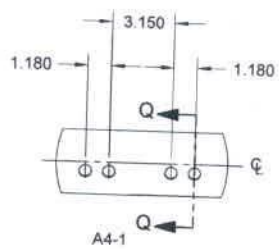
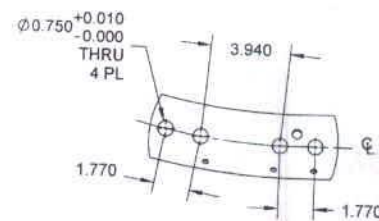
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



#56277



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DESIGN	PE
DRAWN	PE
CHECKED	PE
MFG. APPR.	PE
APPROVED	PE
DE APPR.	PE
DATE	08.07.16

DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWING NO. D2750	REV. F SHEET 5 OF 11
TITLE 350 SKIDTUBE ASSEMBLY	
SCALE NTS	
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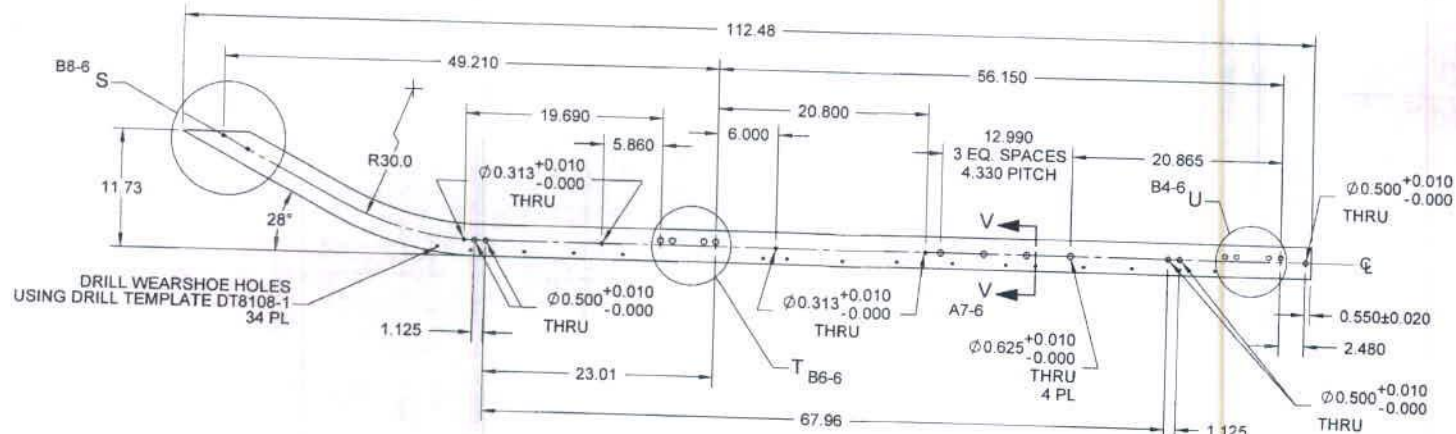
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

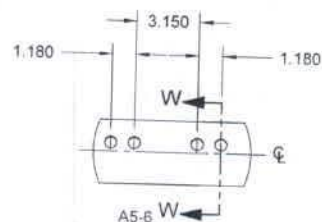
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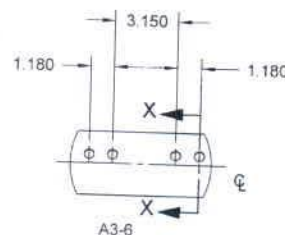
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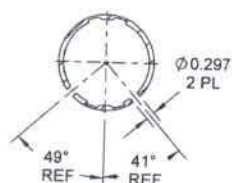
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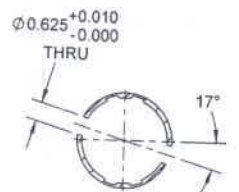
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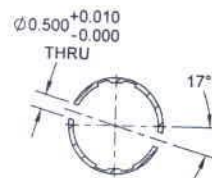
DETAIL U
SCALE 2X



SECTION V-V
SCALE 3X, 17 PL



SECTION W-W
SCALE 3X, 4 PL



SECTION X-X
SCALE 3X, 4 PL

RELEASED
08/12/17

DESIGN	DA	DART AEROSPACE USA, INC.	
DRAWN	DA	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 6 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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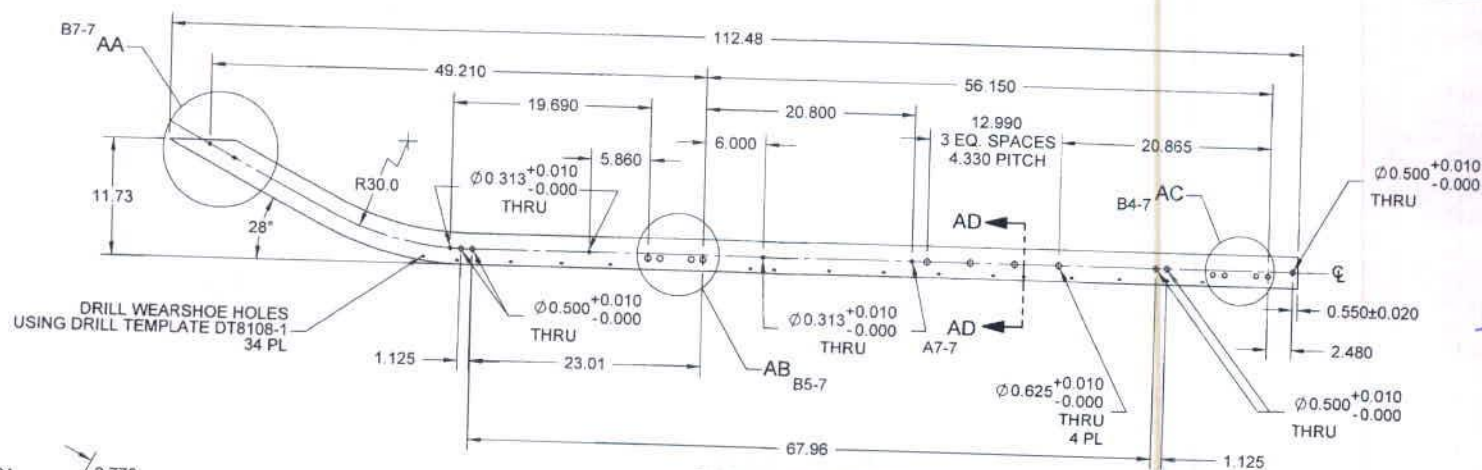
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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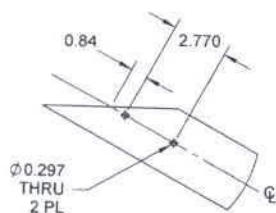
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

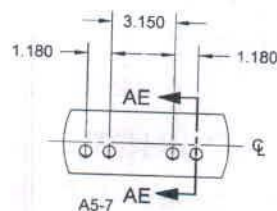
NOTE: Date & initial all entries



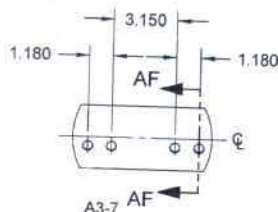
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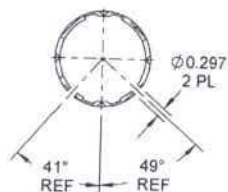
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SCALE 2X



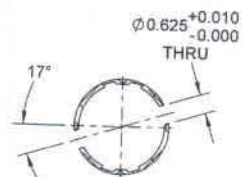
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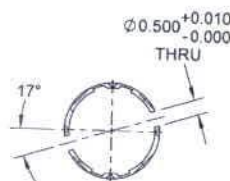
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL



SECTION AF-AF
SCALE 3X, 4 PL

RELEASED
08-04-22-1104

DESIGN	PAH	DART AEROSPACE USA, INC.	
DRAWN	PAH	PORT HADLOCK, WA	
CHECKED	PAH	DRAWING NO. D2750	REV. F
MFG. APPR.	PAH	TITLE 350 SKIDTUBE ASSEMBLY	SHEET 7 OF 11
APPROVED	PAH	SCALE	NTS
DE APPR.	PAH	DATE 08.07.16	
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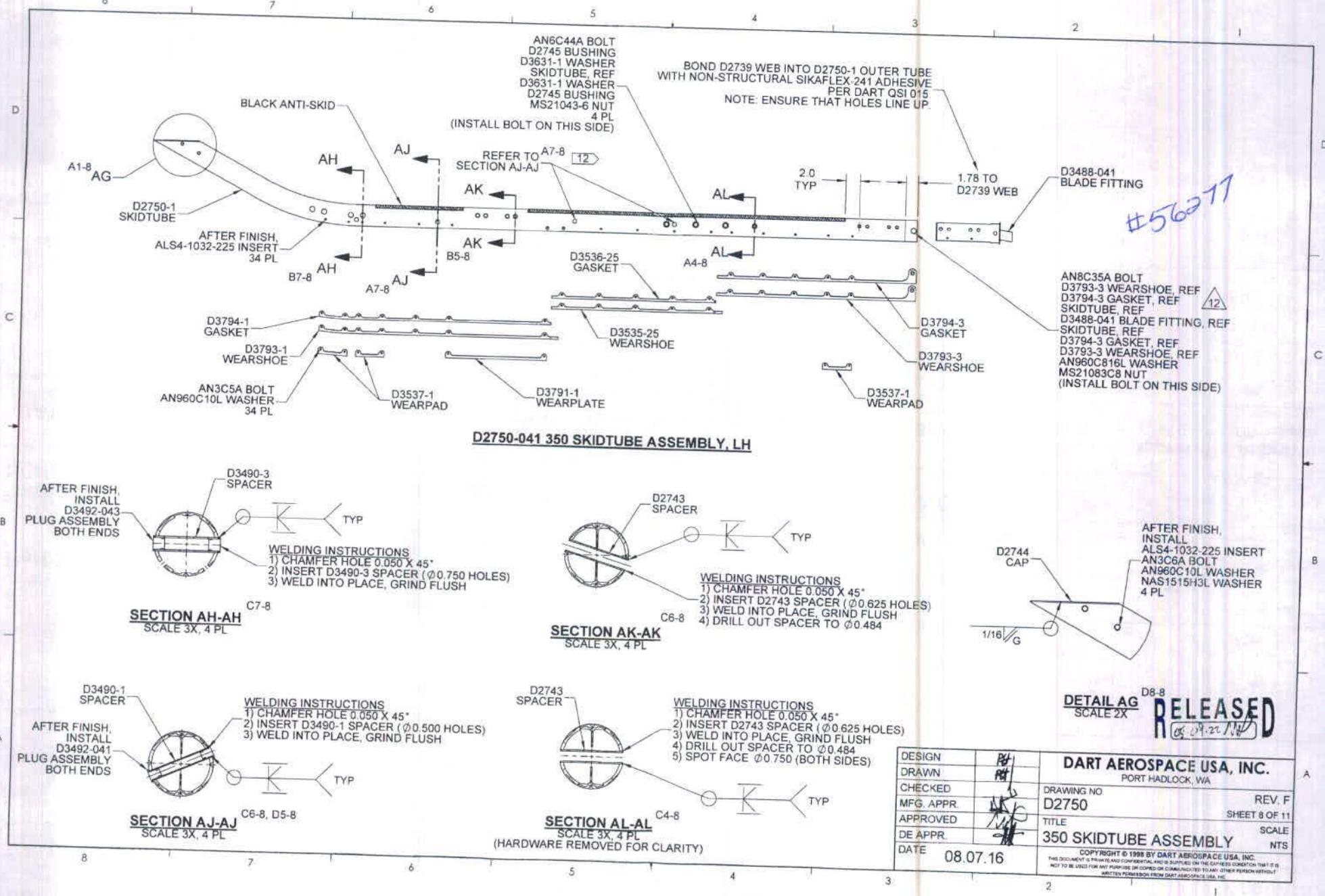
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DETAIL AG D8-8
SCALE 2X
RELEASED
05-09-22-110

DESIGN	PH	DART AEROSPACE USA, INC.	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.	AK	D2750	SHEET 8 OF 11
APPROVED	AK	TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

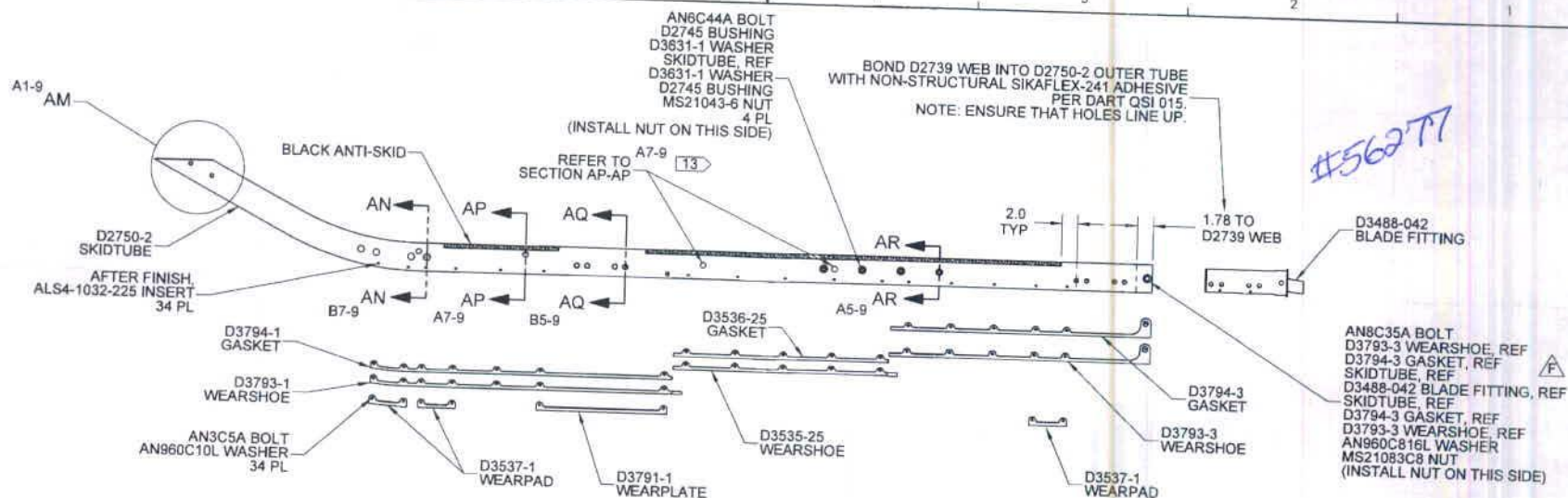
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

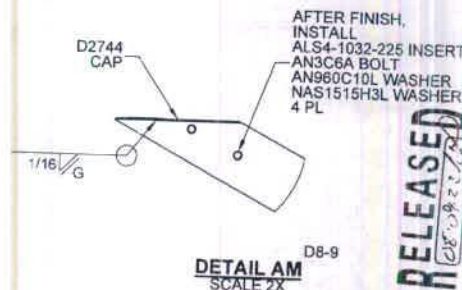
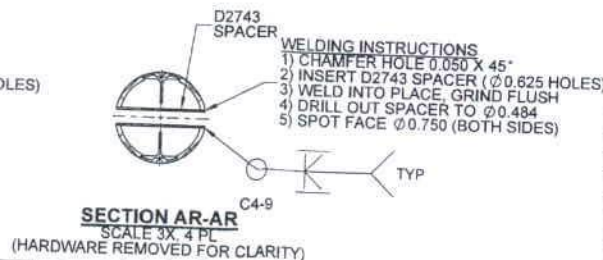
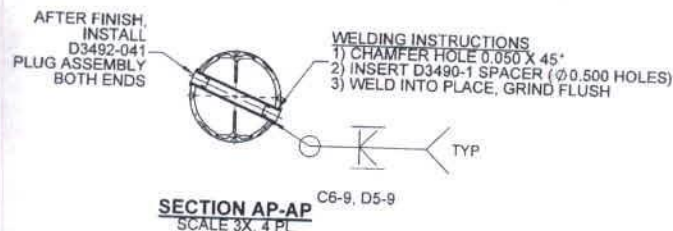
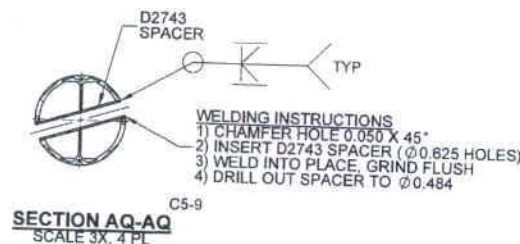
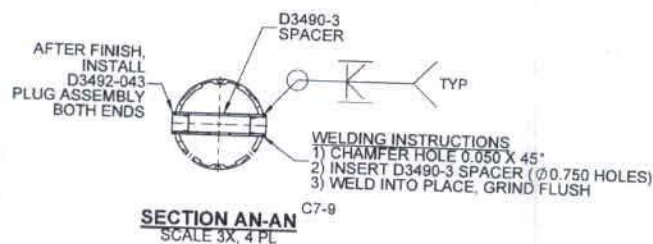
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D2750-042 350 SKIDTUBE ASSEMBLY, RH



DESIGN	PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	REV. F SHEET 9 OF 11
DRAWN	PH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.		TITLE	350 SKIDTUBE ASSEMBLY
DATE	08.07.16	SCALE	NTS

RELEASED
08-10-2017

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

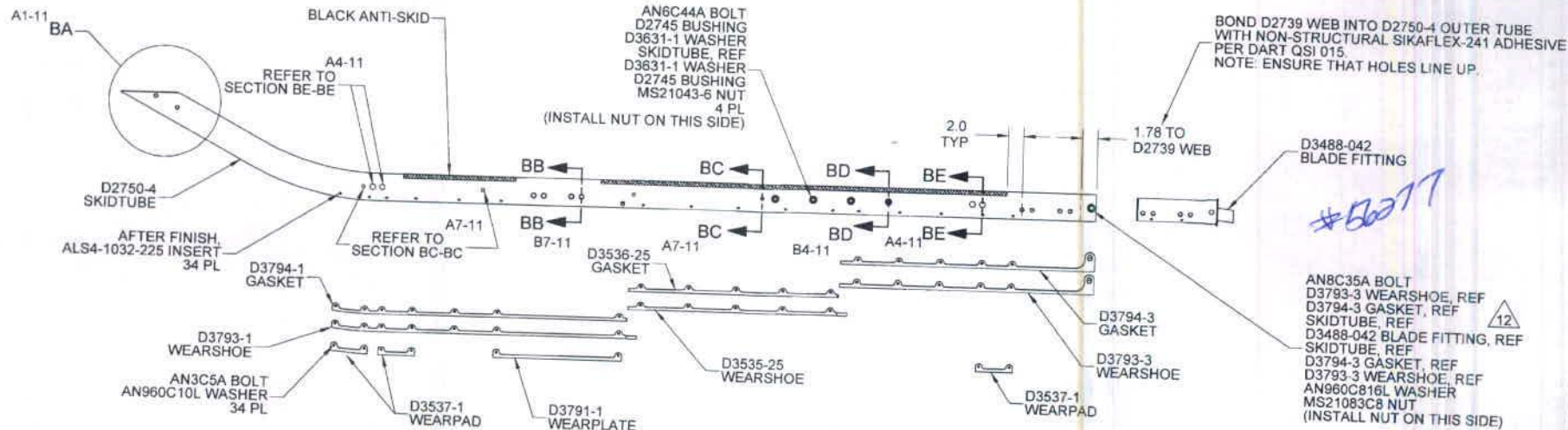
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

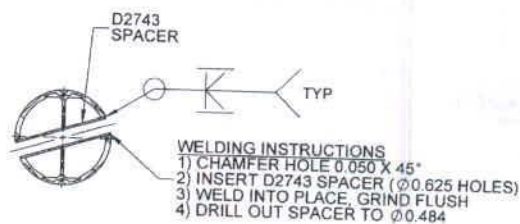
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

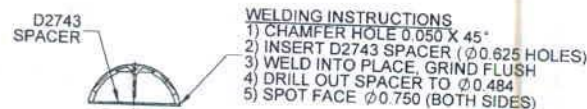
NOTE: Date & initial all entries



D2750-044 350 SKIDTUBE ASSEMBLY, RH



SECTION BB-BB
SCALE 3X, 4 PL



SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL

RELEASED
08-07-16



DETAIL BA
SCALE 2X

DESIGN	PH	DART AEROSPACE USA, INC.	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 11 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1986 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 225

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 56276
Part number: DSSC-636 013
Description: 350 SKID tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:
Penetration:

pass[☒] fail[]
pass[☒] fail[]

UNACCEPTABLE

Cracks:
Undercut:
Pin holes:
Overlap (cold lap)
Porosity (surface):
Coloration:

pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]

Qualifier Pat. D. D.

Date of Test Coupon 10-02-19

Welder Barclay Elliott

Date of Test Coupon 10-02-19

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

